



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.1810
Job Sheet 181416



Part No: 647.1810

Job Qty: 40 ea

Part Name: Nose Door Doubler



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/26/18

Job Tracking No:

Due Date: 9/10/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV N/C SHEET 1 IPP REV:A 12.10.03 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	40 Ea		9/10/18	0.00	0.00	Start Up Waterjet		SC 18/8/09
110	Waterjet	40 pcs		9/10/18	0.00	4.66	Waterjet1		SC 18/8/09
120	QC	40 pcs		9/10/18	0.00	0.00	QC2 Waterjet-1		SC 18/8/09
130	QC	40 pcs		9/10/18	0.00	0.00	QC8-1		18-88-10
140	Outsource	40 pcs		9/10/18	0.00	0.00	Outsource4		18-88-13
150	Packaging	40 pcs		9/10/18	0.00	0.00	Packaging2		AUG 22 2018
160	QC	40 pcs		9/10/18	0.00	0.00	QC5		AUG 22 2018
170	SprayPaint	40 pcs		9/10/18	0.00	5.04	Spray Paint		9-89
180	QC	40 pcs		9/10/18	0.00	0.00	QC14		NIA
190	Packaging	40 pcs		9/10/18	0.00	0.00	Packaging3-1		CCK108 6 AUG 23 2018
200	QC21-SA	40 Ea		9/10/18	0.00	0.00	QC21		AUG 24 2018

Part Op 110 - 1-Cut as per Dwg Dwg Rev: A Prog Rev: A 2-Deburr if necessary
Descriptions: 120 - QC2- Inspect parts off machine FAI/FAIB
130 - QC8- Inspect parts - second check
140 - Outsource process-Anodize per QSI017 4.1.10.1 ISSUE P/O: 040716 HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)
150 - Receive & Inspect for Damage & Mat'l Certs
160 - QC5- Inspect part completeness to step on W/O
170 - PRIME IAW MIL-P-23377J TYPE1 CLASS N AS PER DWG. (SEE NOTE 2) CARDINAL 4860-50 PRIMER BATCH: _____
180 - QC14- Inspect Spray Paint
190 - Identify as per dwg & Stock Location: _____ ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***
200 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.063	2024-T3 .063 Sheet	6.1200 sf (.153 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.063	6	86	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	AGAINST DEPARTMENT/PROCESS Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐	
Date : _____		Step #: _____		QTY Effective : _____		
Dart Aerospace Ltd. 1270 Aberdeen Street Hewkesbury, ON K6A 1K7 CANADA TEL.: 1 813 832-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 08/09/18 Barcode Container No: S100801 Part: 647.1810 Job No: 181416 Serial No/Batch: S100801 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____					Disposition	
					Completed By	
					Lead hand / Supervisor Approval Verification	
					QC / QA Coordinator Approval	
<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td style="width:30%; vertical-align: top;"> CATEGORY ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence </td> </tr> </table>						CATEGORY ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence
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Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Nose Door Doubler	0.102Inches + 0.005 - 0.001	0.107 0.101	0,104	Diameter
2	Nose Door Doubler	0.700Inches $\pm$ 0.005	0.705 0.695	0,702	
3	Nose Door Doubler	3.400Inches $\pm$ 0.005	3.405 3.395	3,404	
4	Nose Door Doubler	4.200Inches $\pm$ 0.002	4.202 4.198	4,202	
5	Nose Door Doubler	2.000Inches $\pm$ 0.005	2.005 1.995	2,001	
6	Nose Door Doubler	11.000Inches $\pm$ 0.005	11.005 10.995	11,005	
7	Nose Door Doubler	0.063Inches $\pm$ 0.005	0.068 0.058	0,063	

Plex 7/26/18 8:31 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040716**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040716
PO Date: 8/10/18
Due Date: 8/24/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, Chrisoula

Via: Ground
Pynt Terms: Net 30

Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	175629	C2-1-1	Manual Release Knob -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A- 8625 TYPE-2 CLASS- 2, Water sealant -Certificate of Conformity is required	Firmed	-	8/15/18	20 pcs	0 pcs	20 pcs	\$7.60/pcs	\$152.00
20 X AUG 14 2018											
Line Item Note **super rush **											
2	179588	646.9910	Struts Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 646.9900 rev. N/C	Firmed	-	8/20/18	12 pcs	0 pcs	12 pcs	\$14.75/pcs	\$177.00
12 X AUG 17 2018											
Line Item Note ** another rush **											
3	181382	647.1612	Splice Plate Issue P/O ATG, balck anodize and prime as per dwg 647.1612 Rev. A	Firmed	-	8/24/18	60 pcs	0 pcs	60 pcs	\$8.25/pcs	\$495.00
60 X AUG 17 2018											
4	181416	647.1810	Nose Door Doubler Outsource process- Anodize per QSI017 4.1.10.1 ISSUE P/O: HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)	Firmed	-	8/24/18	40 pcs	0 pcs	40 pcs	\$10.85/pcs	\$434.00
40 X AUG 22 2018											
Grand Total:											\$1,258.00

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/14/18 10:18 AM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 915837

Date: 20-Aug-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
40 ea	Part: 647.1810 Nose Door Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 23566	Rev: A	PO: PO040716 Line: 4
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>20/8/18</u> Certified Signature: _____ Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			

